

Work Order ID 86833

July-06-12 3:04:04 PM

86833

Page 1

Item ID: D2602-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Console Side, 206 Console
 Start Date: 7/06/12 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 8/17/12 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: Date: 12-07-12 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					8			
D2602	Rev B								
100	FLOW WATER JET	0.00							
100									B12-7-24
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2602 *****Same Cutting File for -1 & -2 ***** Dwg								
2024 - 040	Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									B12-7-24
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120						8			
QC	Memo	0.00							
Quality Control									

SMB
12-7-24
DAS
16
7/6/125

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							12/18/16 SP

Quality Control

170	Identify as per dwg & Stock Location: <u>178</u>	0.00							
170									
Packaging	Memo	0.00							sl sl 12/08/16

Packaging

180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							MLJ 12/08/17

Quality Control

MLJ 12/08/16

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Picklist Print

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Page 1

Work Order ID: 86833

Parent Item: D2602-1

Parent Item Name: Console Side, 206 Console

Start Date: 7/06/12

Required Date: 8/17/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP D04.02.25ReformatKJ/RF
Note: Issue with part number D2602-2
IPP Rev:E Now On Waterjet 07-03-22 JLM
IPP Rev:F RevB as per dwg ECN1059 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	178.1612	1.3472	8.5086318		B12-7-24	

Location

Loc Qty

Loc Code

MAT022

178.1611626

120605

49.6627416

121197

32.498421

122136

96

122136

8

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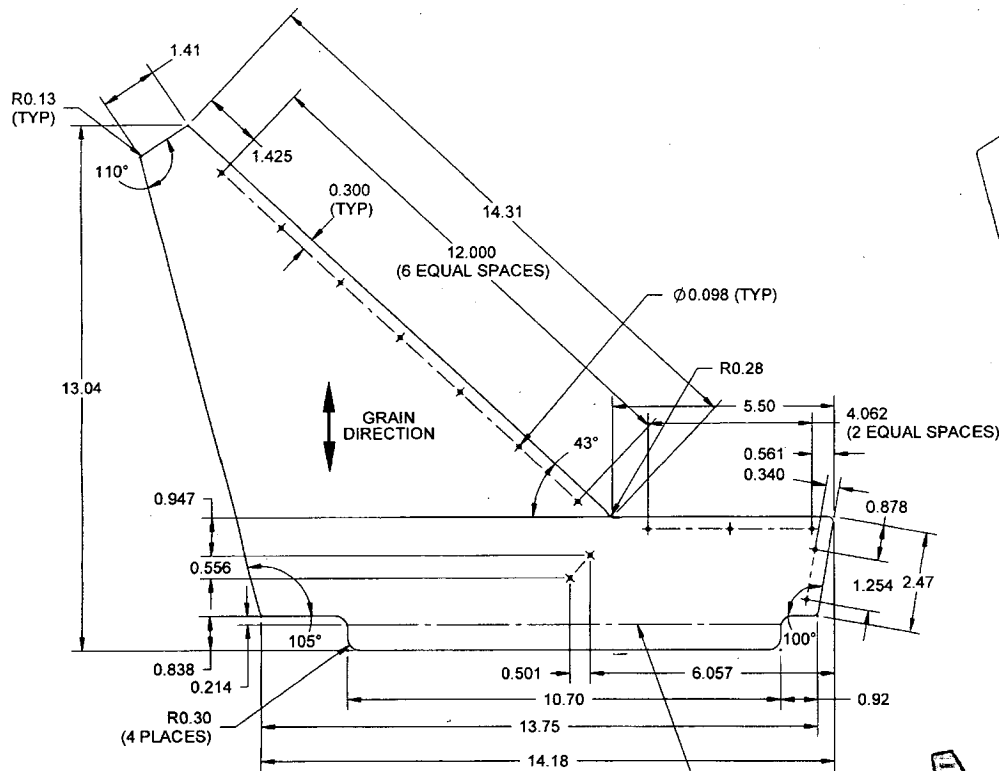
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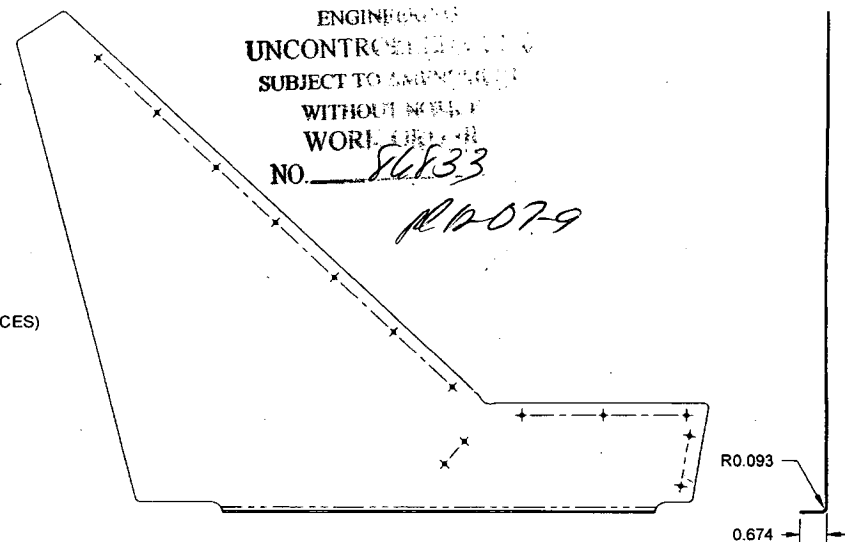
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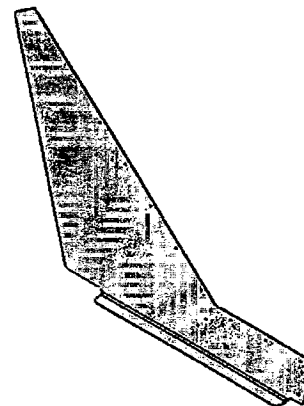
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D2602-1F FLAT PATTERN



**D2602-1 CONSOLE SIDE (MAKE FROM D2602-1F)
(D2602-2 OPPOSITE)**



- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.38 lbs

SHOWING
RETURNED
ENGINEERING
UNCONTROLLED
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
NO. *86833*

RPD-07-9

RELEASED
67-12-12

B	ADD GRAIN DIRECTION, UPDATE DIMS, GENERAL UPDATE, INCORPORATED HAND CHANGES	DC	07.11.07
A	D2602 WAS D206-547-21/-22	BW	97.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	DRAWING NO.	REV. B
MFG. APPR.	KE	D2602	SHEET 1 OF 1
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	CONSOLE SIDE	1:3
DATE	07.11.07	COPYRIGHT © 1997 BY DART AEROSPACE LTD	
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